

# Work Order ID 91475

October-10-12 2:47:43 PM

**\*91475\***

Page 1

Item ID: D4543-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, RH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12-10-10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4543	A								
100		0.00							
<b>*100*</b>									
Waterjet		0.00				15	0		Jm 12-11-06
FLOW CNC Waterjet									
60061-032									
	Memo								
	1- Cut as per dwg								
	Prog rev: <u>15</u>								
	Dwg rev: <u>15</u>								
	2- Deburr								
110		0.00							
<b>*110*</b>									
QC		0.00				15	0		Jm 12-11-06
Quality Control									
	Memo								

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Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
15  
12.11.07

15

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

15 FF  
12-11-15

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DAS  
15  
12.11.12

15

# Work Order ID 91475

**\*91475\***

Page 3

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Item ID: D4543-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, RH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

150 Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

15 16 12/11/20

160 QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

QAS  
15  
12/11/20

15

170 Identify as per dwg & Stock Location: ST128

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

15

12/11/20 JB

**Work Order ID 91475**

October-10-12 2:47:43 PM

**\*91475\***

Page 4

Item ID: D4543-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Retainer, Outer, RH

Stop **\*NS2\***

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/11/22 *[Signature]**mf*

12-11-21

# Picklist Print

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Page 1

Work Order ID: 91475

\*91475\*

Parent Item: D4543-2

\*D4543-2\*

Parent Item Name: Retainer, Outer, RH

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD  
12.02.24 as per dwg reva DD verf:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

700.0600

0.611

~~9.647368~~

\*\*

9.7

Jan 12-11-06

\*M6061T6S 032\*

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

123135

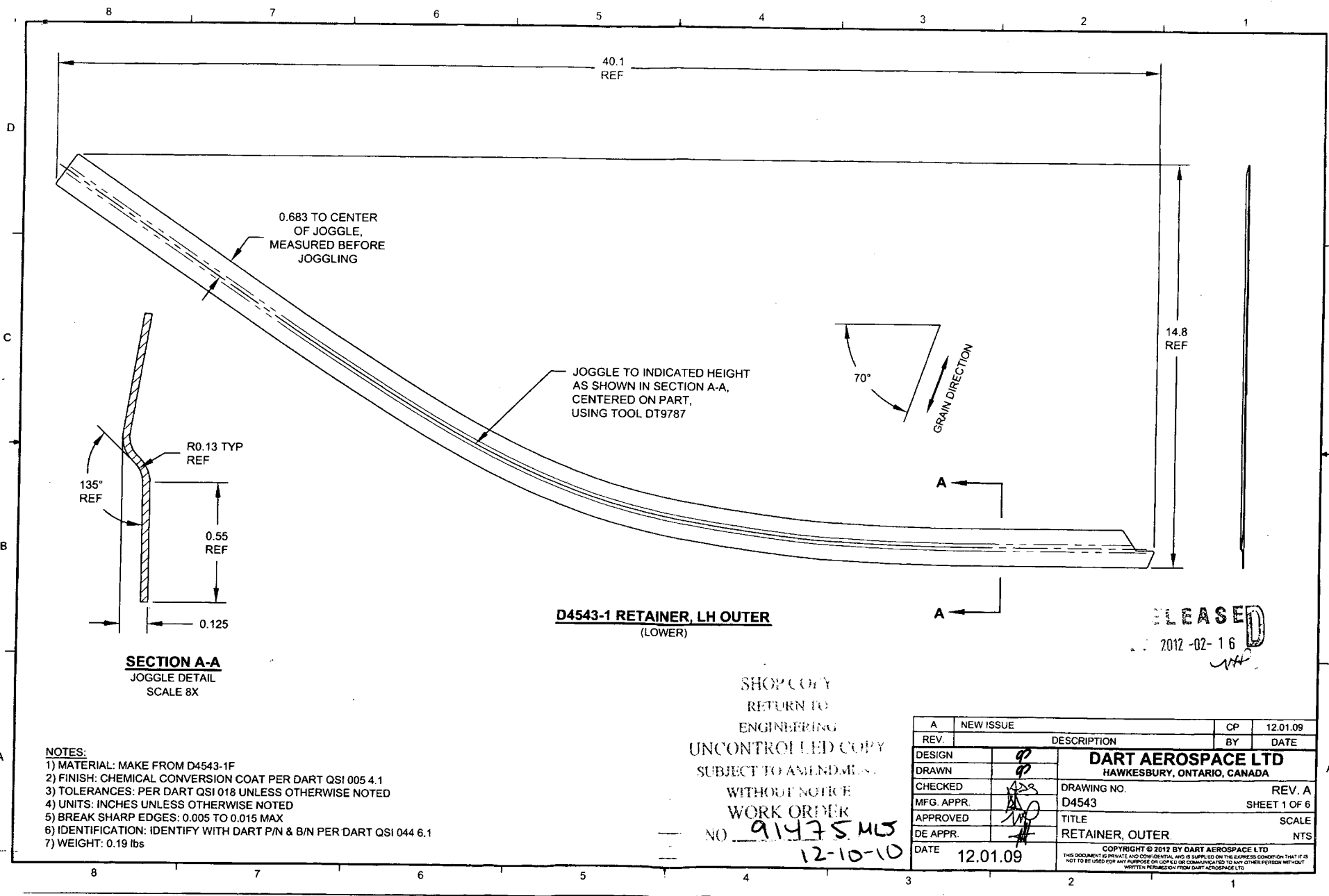
96

123137

356

123137





**D4543-1 RETAINER, LH OUTER**  
(LOWER)

**SECTION A-A**  
JOGGLE DETAIL  
SCALE 8X

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 0.19 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTS

WITHOUT NOTICE  
WORK ORDER  
NO **91475 ML3**  
**12-10-10**

A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.09		

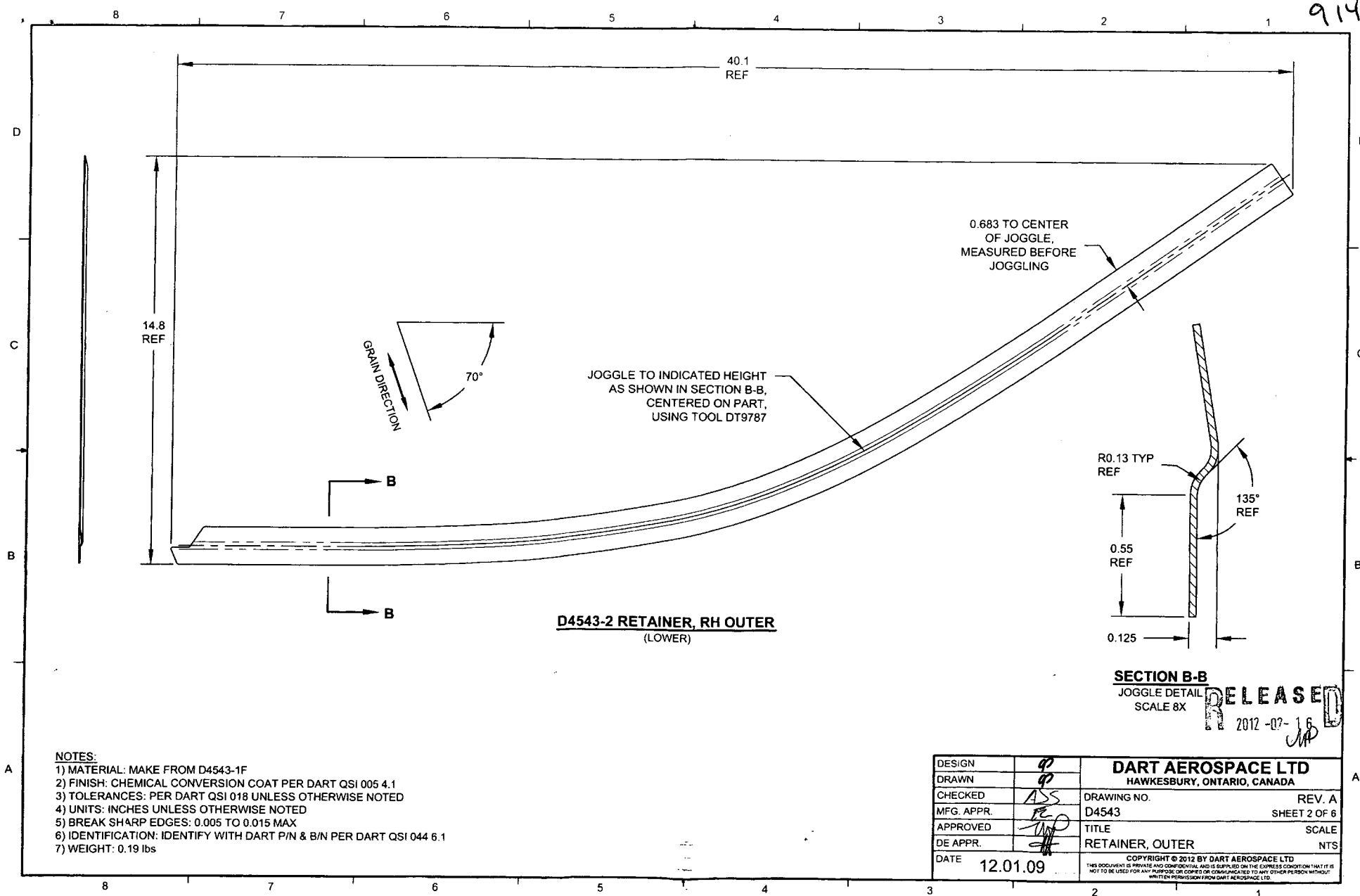
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4543	REV. A
TITLE RETAINER, OUTER	SHEET 1 OF 6
SCALE NTS	

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2012-02-16  
*W*

91475



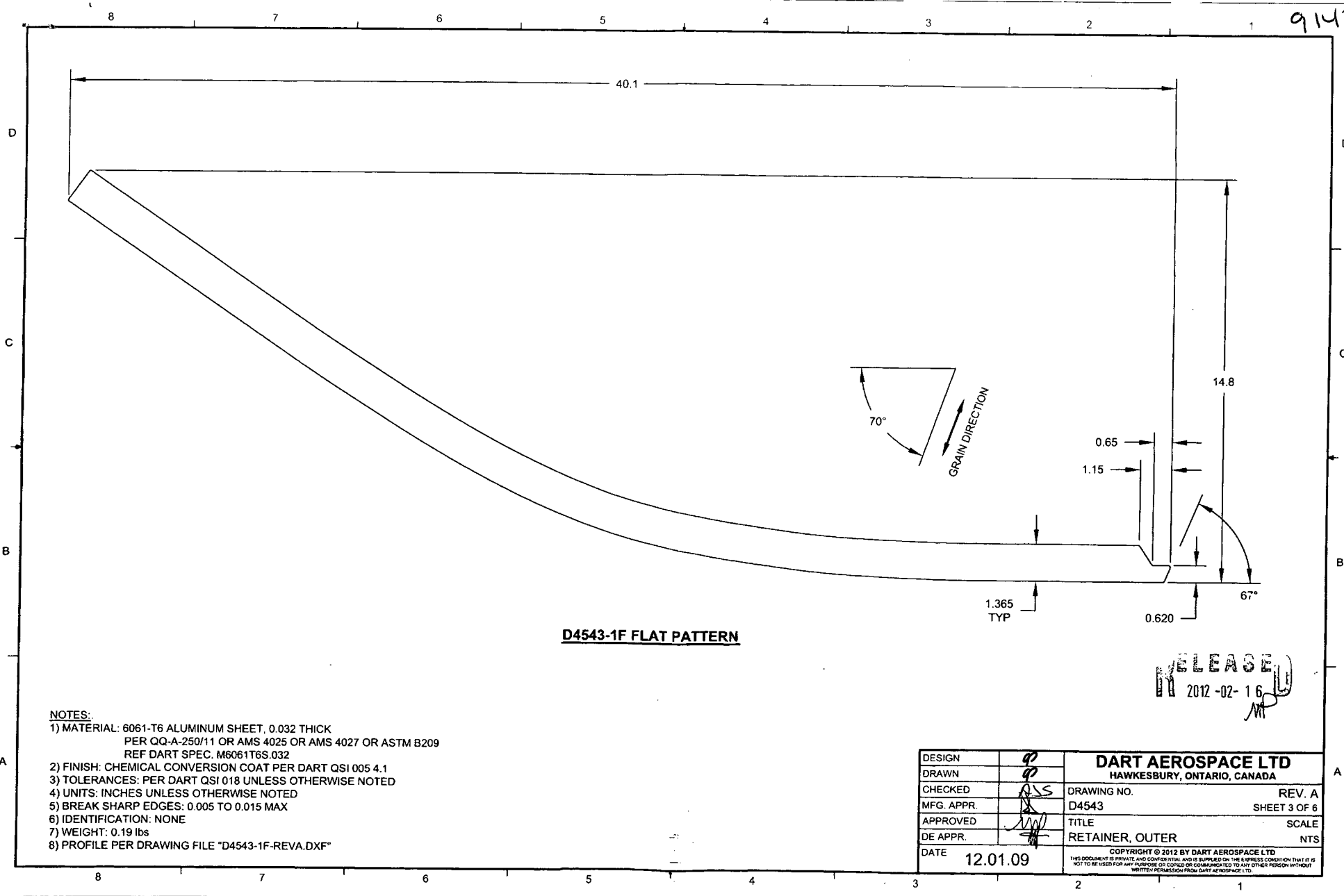
NOTES:

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	FE	D4543	SHEET 2 OF 6
APPROVED	WJP	TITLE	SCALE
DE APPR.	JH	RETAINER, OUTER	NTS
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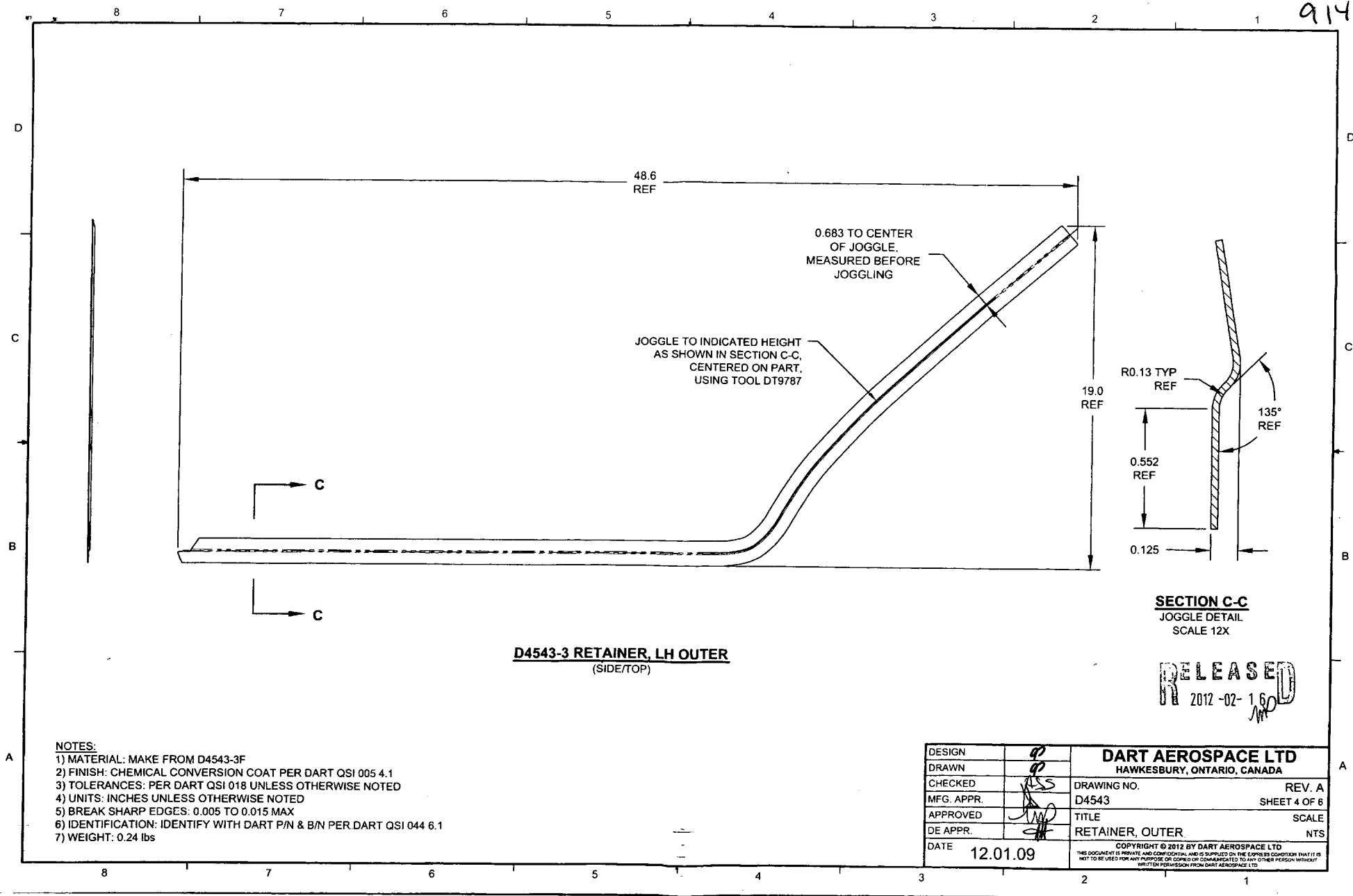
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

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2012-02-16

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DE APPR.		RETAINER, OUTER	NTS
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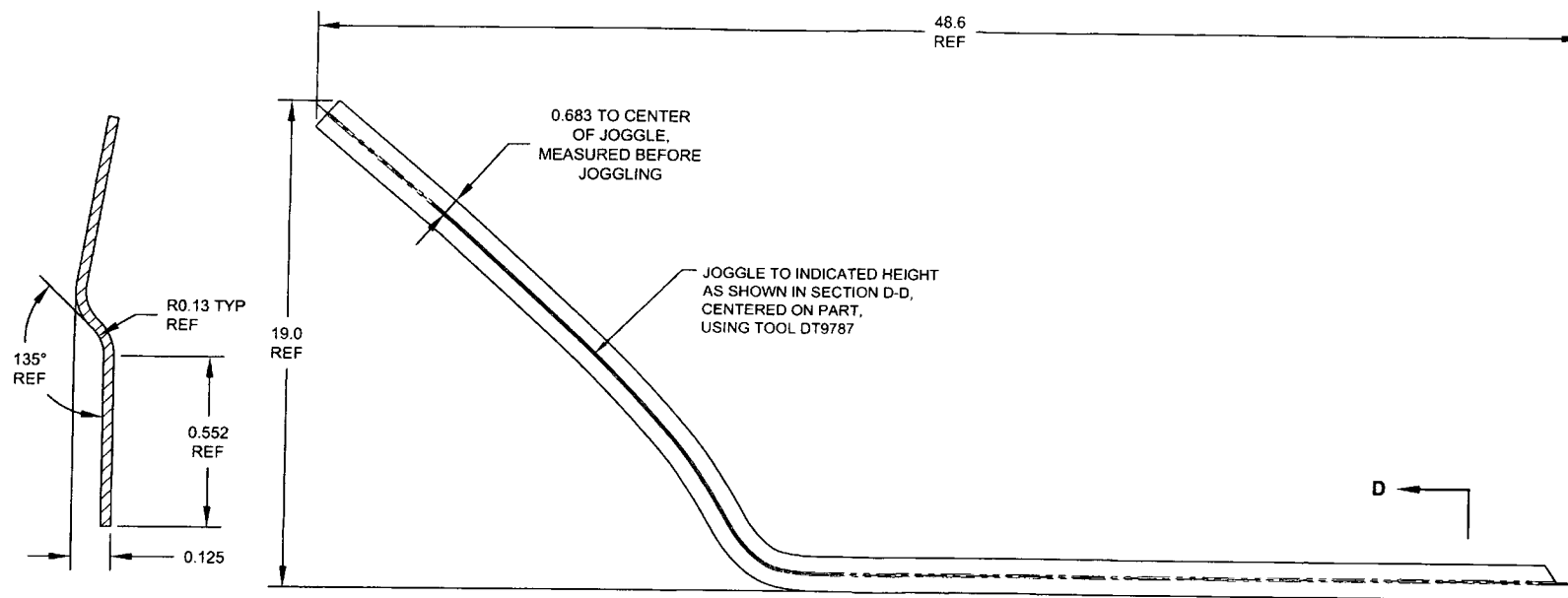


**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	<i>JP</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 4 OF 6
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DE APPR.	<i>[Signature]</i>	RETAINER, OUTER	NTS
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91475



**SECTION D-D**  
JOGGLE DETAIL  
SCALE 12X

**D4543-4 RETAINER, RH OUTER**  
(SIDE/TOP)

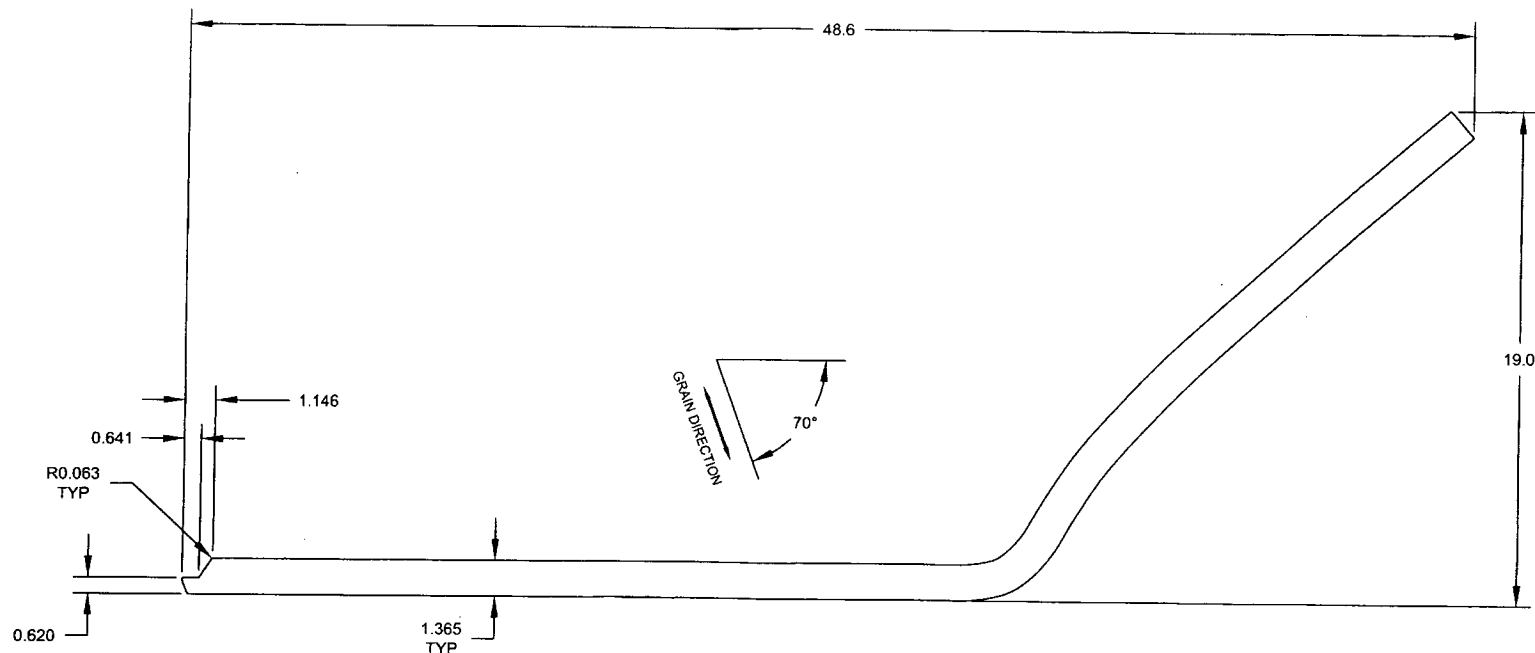
RELEASED  
2012-02-16

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	q	<b>DART AEROSPACE LTD</b>	
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CHECKED	AYS	DRAWING NO.	REV. A
MFG. APPR.	AYS	D4543	SHEET 5 OF 6
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DE APPR.	#	RETAINER, OUTER	NTS
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**D4543-3F FLAT PATTERN**

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REF DART SPEC. M6061T6S.032
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4543	SHEET 6 OF 6
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